


# Work Order ID 95610

\*95610\*

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Item ID: D2873-045 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Nut Plate Assembly  
 Start Date: 1/15/13 Start Qty: 40.00 \*40\* Cust Item ID:  
 Required Date: 1/22/13 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								
100		0.00							
*100*	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 2.700" long								
110		0.00							
*110*	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev <u>A</u> F1819Folio Rev <u>AA</u>								
120		0.00							
*120*	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

2 B-0116

40

PO 13/01/17

40

0

PO 13/01/17

40

0

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		B.A 13/01/18		40	0		DAS 08 9-89
140 <b>*140*</b> Small Fab Small Fab	Small Fab  Memo 1-Deburr 2- C'sink as per Dwg D2873	0.00  0.00				40x			EP 13/01/12
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		DAS 15 9-89 B 121		40			

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 Required Date: 1/22/13 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				4		13121	
170 <b>*170*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				40			13/01/21
180 <b>*180*</b> Small Fab Small Fab Small Fab	Small Fab  Memo 1-Assemble as per Dwg D2873 2-Identify as D2873-045	0.00  0.00				40			13/01/21

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 Required Date: 1/22/13 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				40 count			
200 *200* Packaging Packaging	Identify as per dwg & Stock Location <u>LG050</u>  Memo	0.00 0.00							
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

13/1/23  
 13-01-22

# Picklist Print

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Work Order ID: 95610

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly

Start Date: 1/15/13

Required Date: 1/22/13

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.000 6061T6 BAR .375 x 1.00		Purchased	No			180	f	8.4470	0.225	9.4736842			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT002		8.44695							
				123372		7.096							
MS20426AD4-6 Rivet		Purchased	No			180	Each	2,146.0000	4	160			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1765							
				122814		1765							
				ST334		381							
				121708		381							
MS21075L5 Nut Plate		Purchased	No			100	Each	56.0000	2	80			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST318		56							
				123346		56							

6061-T6 B.  
1/2 x 1.00  
This batch only.

M124316  
80x

SL 13-01-16  
3.15 not pulled  
7.096  
160  
13/01/21  
160  
13/01/21

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 9560
<b>Description:</b> Radius Block		<b>Part Number:</b> D2873-5
<b>Inspection Dwg:</b> D2873	<b>Rev:</b> A	<b>Page 1 of 1</b>

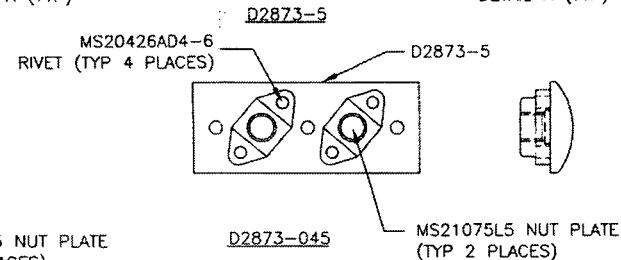
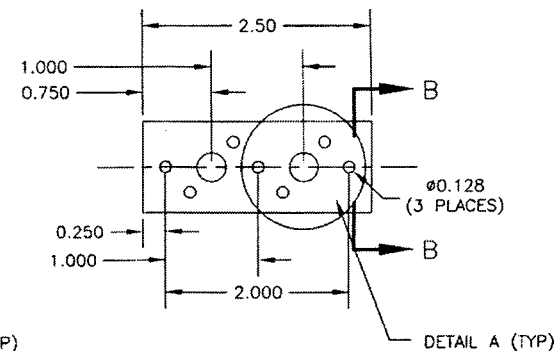
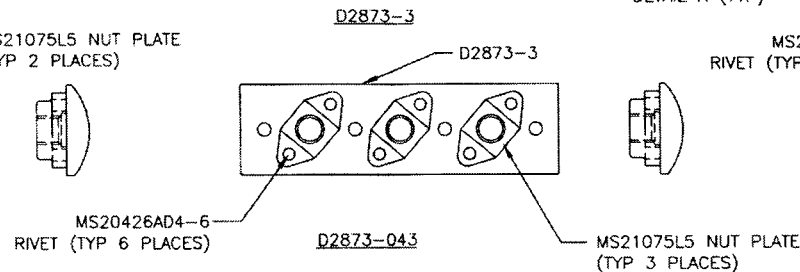
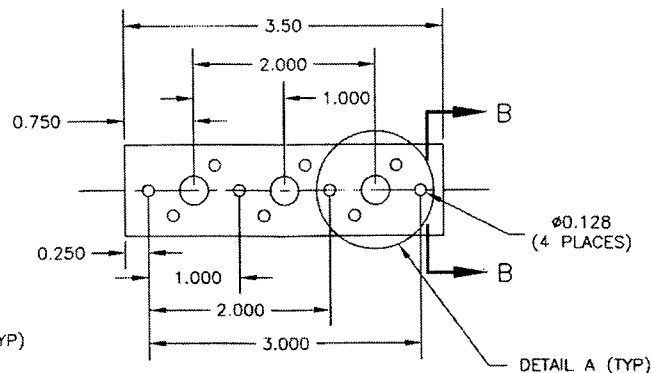
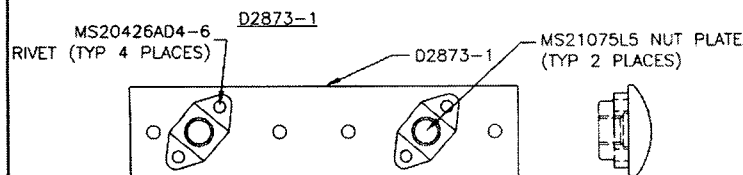
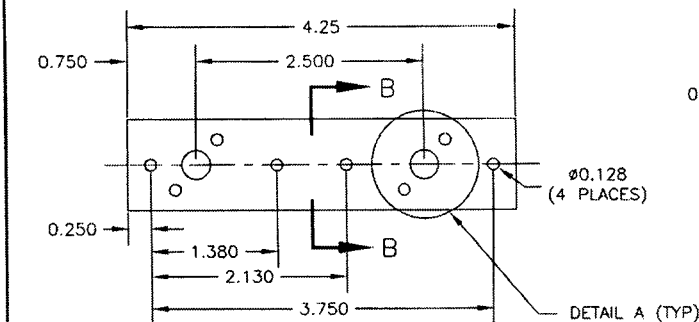
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	✓		VERN	PHO-01
1.000	+/-0.010	1.007	✓		"	"
0.750	+/-0.010	.748	✓		"	"
0.250	+/-0.010	.247	✓		"	"
1.000	+/-0.010	.996	✓		"	"
2.000	+/-0.010	1.996	✓		"	"
Ø0.128	+0.005/-0.001	.130	✓		Pin g.	
0.359	+/-0.010	.358	✓		VERN	PHO-01
Ø0.316	+0.006/-0.001	.316	✓		Pin g	
1.000	+/-0.010	1.000	✓		VERN	PHO-01
0.250	+/-0.010	.247	✓		Mic	PHO-02
0.061	+/-0.010	.060	✓		VERN	PHO-01
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230	✓		Pin g	
.125	± .010	.125	✓		MC	112-117

<b>Measured by:</b> PD	<b>Audited by:</b> D.A. 08	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 13/01/17	<b>Date:</b> 13/01/18	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	



#### D2873-1/-3/-5 RADIUS BLOCK

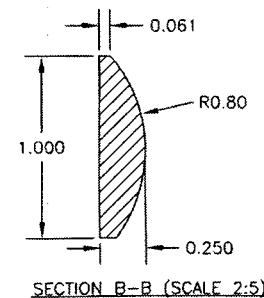
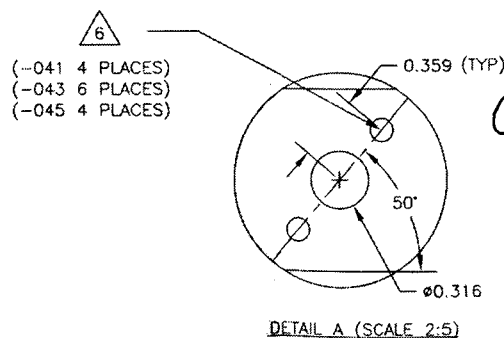
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

RELEASED  
05.07.26